

Date: Thursday, 17/04/2008 7:42:44 AM  
 User: Linda Lacelle

## Process Sheet

*Spirit 11/10*  
*08/05/13*

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 38650  
 Estimate Number : 10385  
 P.O. Number :  
 This Issue : 17/04/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 17/04/2008 Type : SMALL /MED FAB  
 Previous Run : 35626  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev: C-02.11.01 Incorporated D3066-1 IPP KJ/RF

Drawing Name : HI-STEP LEG ASSEMBLY  
 Part Number : D3065041  
 Drawing Number : D3065 REV B  
 Project Number : N/A  
 Drawing Revision : B  
 Material :  
 Due Date : 06/05/2008 Qty: 400 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 38650A STEP SPACER



Comment: Sub-Component STEP SPACER  
 D3065-1 B 38650A



2.0 38650B STEP SPACER



Comment: Sub-Component STEP SPACER  
 D3065-3 B 38650B



3.0 38650C STEP LEG



Comment: Sub-Component STEP LEG  
 D3065-5 B 38650C



4.0 38650D STEP SPACER



Comment: Sub-Component STEP SPACER  
 D3065-7 B 38650D B37771



5.0 MS20470AD44 Rivet, Universal Head



Comment: Qty.: 30.0000 Each(s)/Unit Total : 3000.0000 Each(s)  
 Rivet, Universal Head  
 Pick:



Qty Part Number Description  
 30 MS20470AD4-4 Rivet

Batch

M107823

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User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 38650

Part Number: D3065041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3065 and Identify as D3065-041

*08/06/20 (50)*  
*08/06/23 (x50) counter*

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WA 17.18.19*

*08.06.25 50*

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*(50)*  
*D 08/06/26*

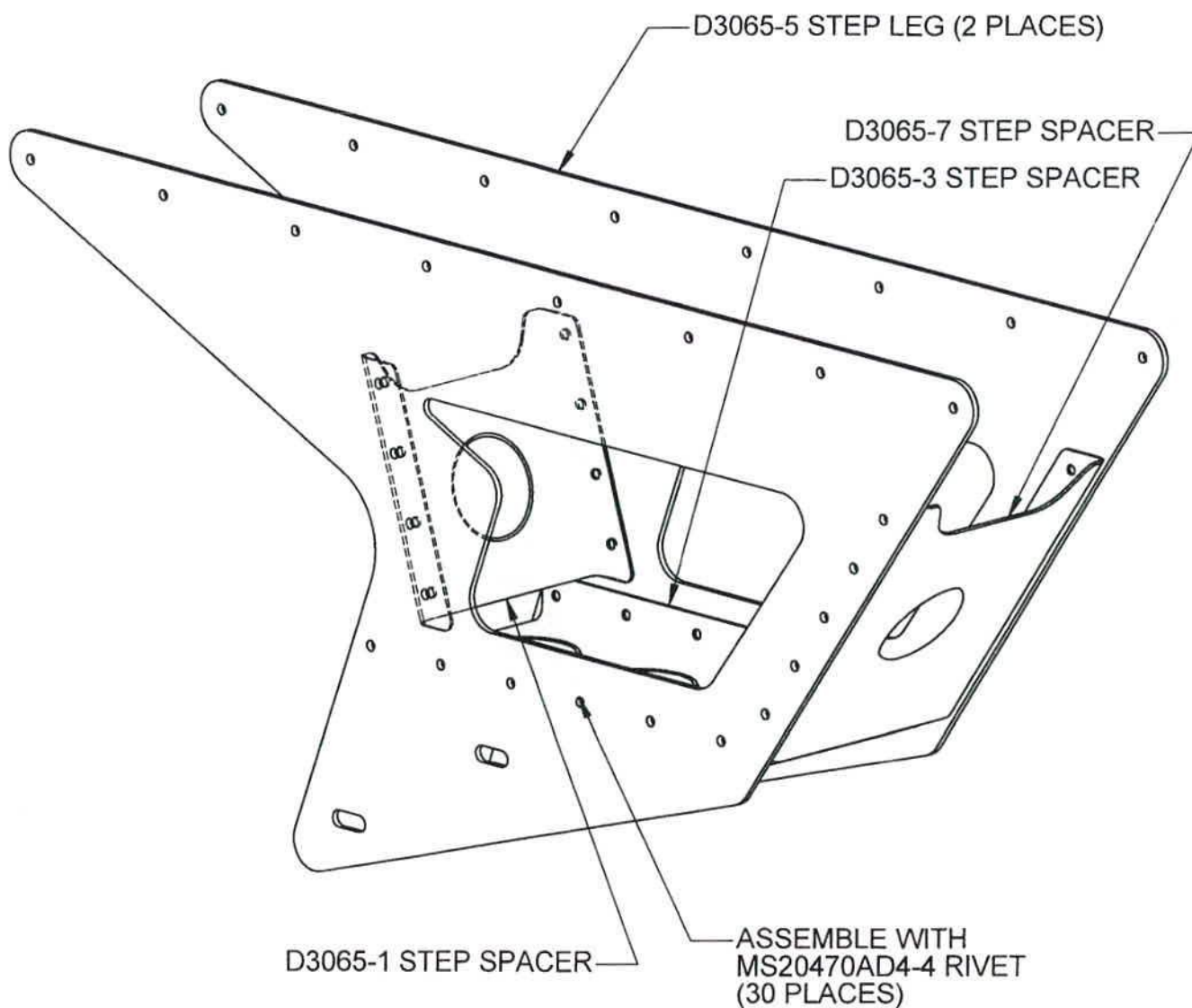
Job Completion



*MF 08-06-26*

**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3065</b>	REV. B SHEET 1 OF 5
DATE <b>06.05.23</b>		TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

**RELEASED***06.06.20* *[Signature]*

### **D3065-041 STEP LEG ASSEMBLY**

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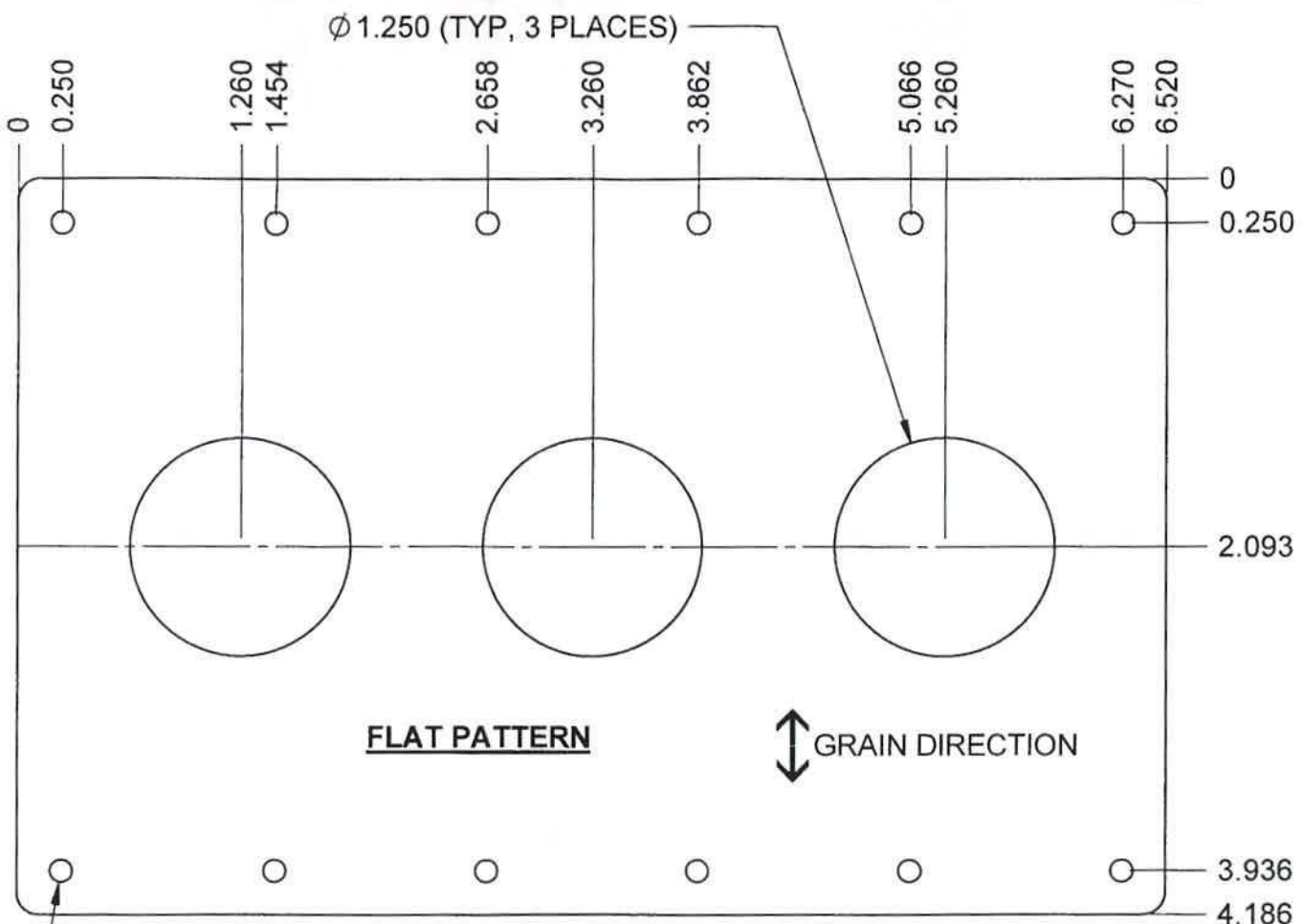
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*08/04/17*  
*W/O: 38650*



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DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1



FLANGE AFTER TOWARDS SIDE  
SHOWN USING DT8174 (3 PLACES)

Ø 0.129 (TYP, 12 PLACES)

RELEASED

*OK to go*

BEND DETAIL

### D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)  
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

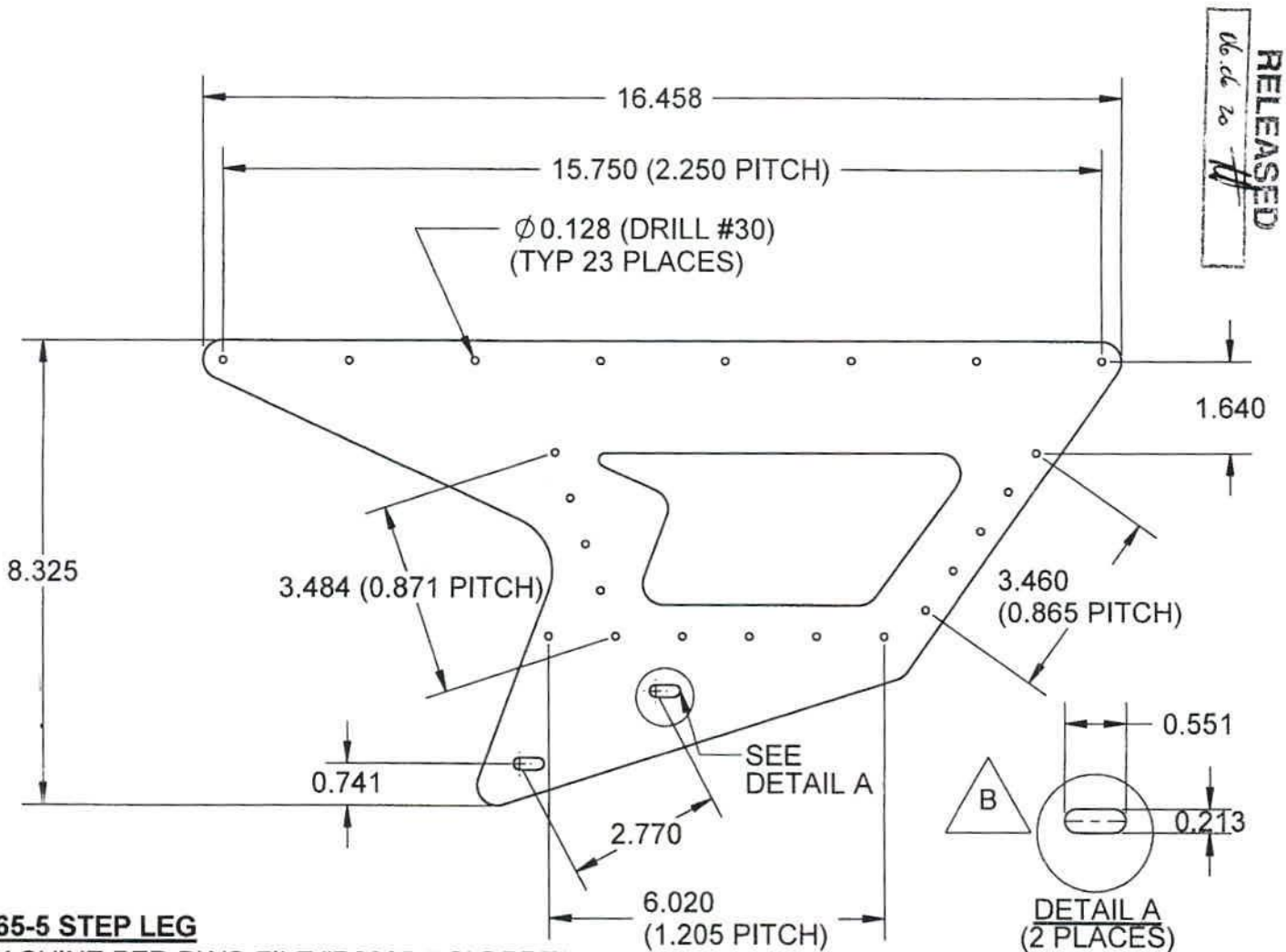
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*C208/04/17*  
*W10:38650*

# DART

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CHECKED	PH	APPROVED	[Signature]	
DATE	06.05.23	TITLE	STEP LEG ASSEMBLY	
		SCALE	1:3	



### D3065-5 STEP LEG

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"  
2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK  
(REF DART SPEC M6061T6S.080)  
OR  
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)  
3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1  
4) BREAK ALL SHARP EDGES 0.005 TO 0.010  
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
6) ALL DIMENSIONS ARE IN INCHES

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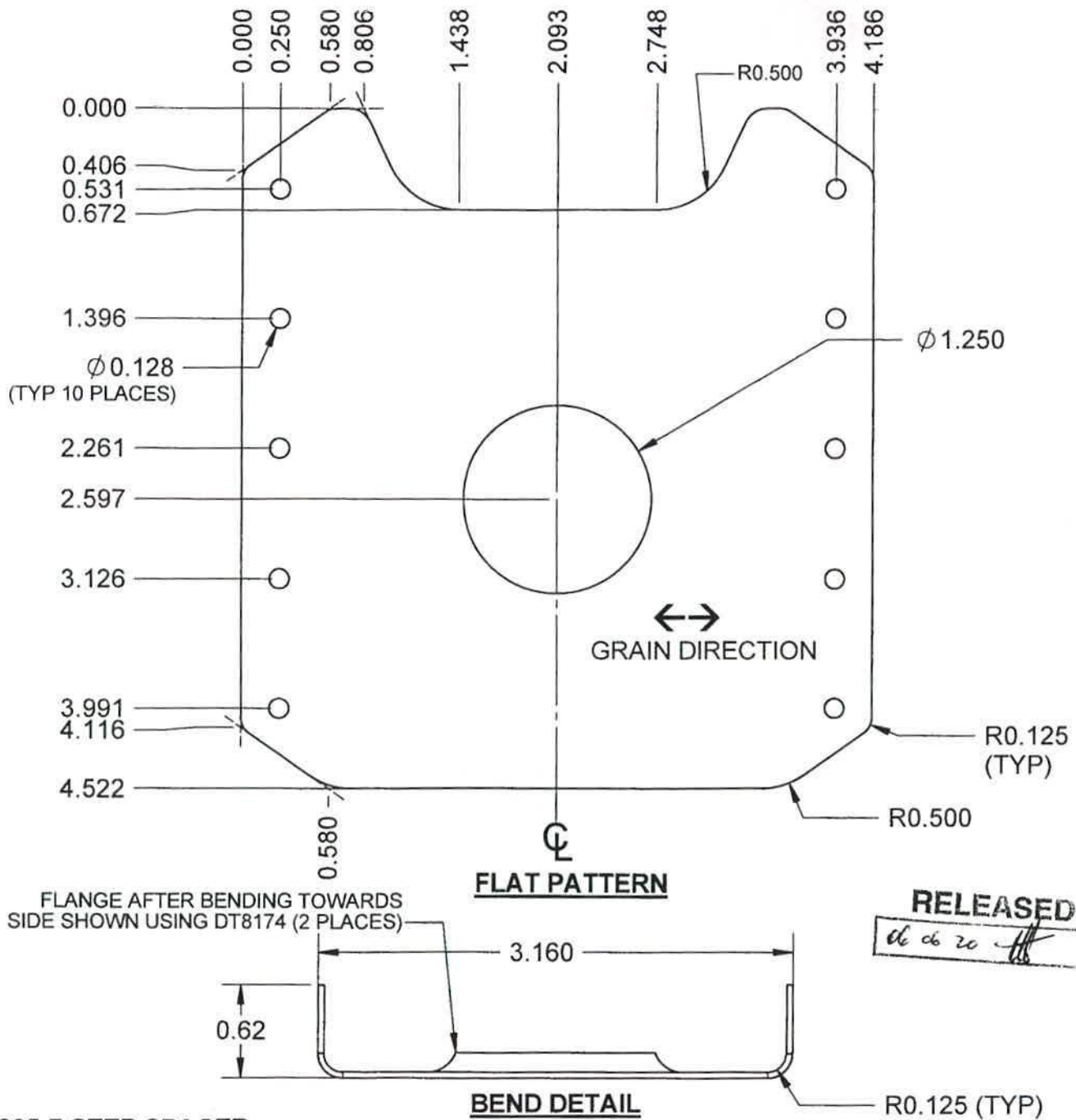
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C202104/117

4/10: 38650

**DART**

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3065</b>	REV. B SHEET 5 OF 5
DATE <b>06.05.23</b>		TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:1

**D3065-7 STEP SPACER**

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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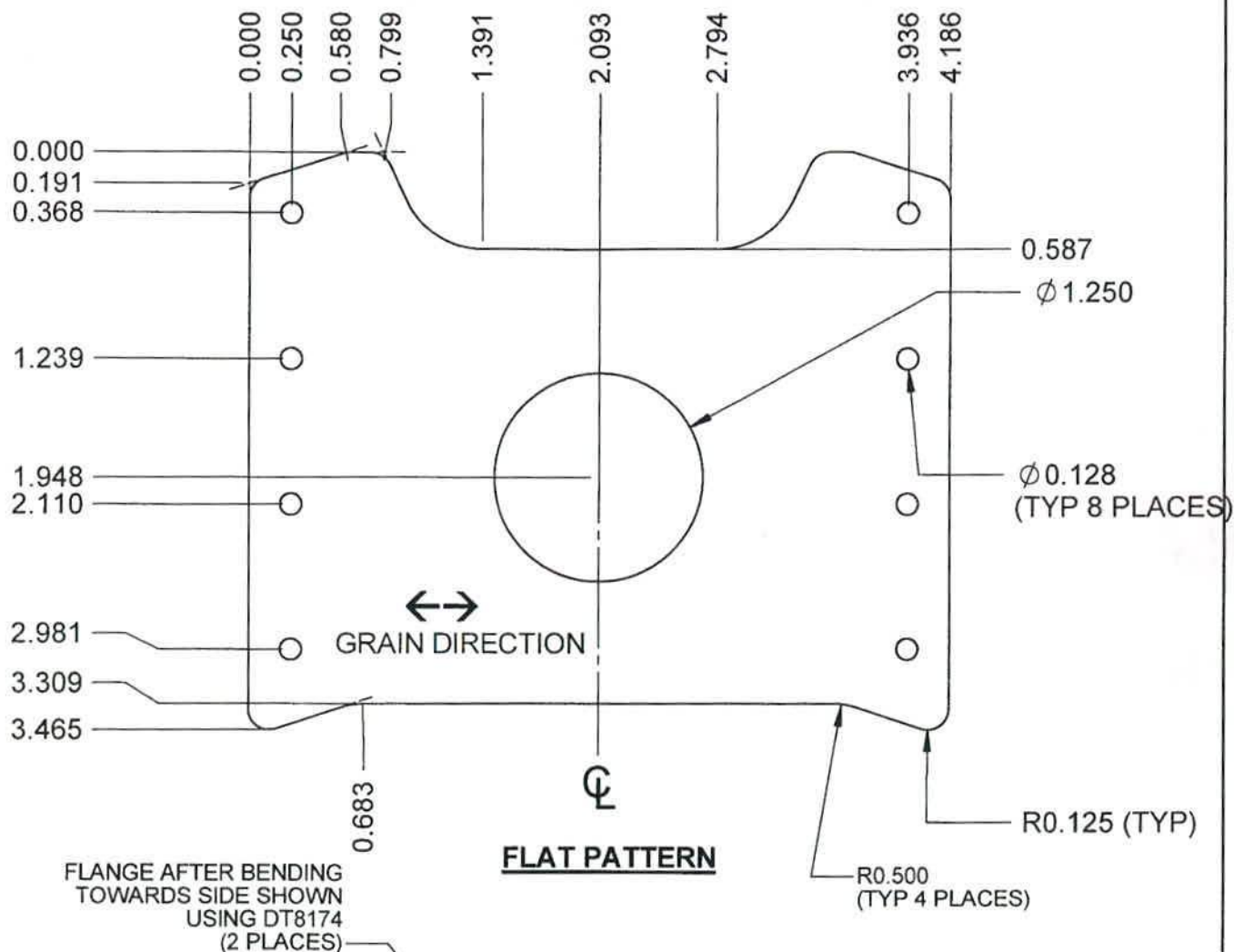
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*C208/04117*  
*W10: 38650*



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CHECKED <i>PH</i>	APPROVED <i>HA</i>	DRAWING NO. <b>D3065</b>	REV. B SHEET 2 OF 5
DATE <b>06.05.23</b>		TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:1

**RELEASED***cl de ro HA***D3065-1 STEP SPACER****BEND DETAIL**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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*cl 08/04/17  
W/0: 38650*